

Work Order ID 160829

Thursday, May 04, 2017 2:48:38 PM

160829

Page 1

Item ID: PB67-43001-247

Revision ID:

Item Name: Inner Tube

Start Date: 5/10/2017 Start Qty: 7.00

Required Date: 5/17/2017 Req'd Qty: 7.00

Reference: SCHEDULED/U

Accept
MAY 23 2017

DAS
13
9-89

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

7

7

Approvals: Process Plan: DAS 21 9-89 Date: **MAY 05 2017** Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001	C

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100

Small Fab

Small Fab

Small Fab

Memo

1- cut to length as per dwg

2- deburr

QC5- Inspect part completeness to step on W/O	0.00
---	------

110

QC

Quality Control

Memo

0.14

120

120

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

1- drill hole as per dwg

2- deburr

0.00

1.77

DAS
13
9-89

DAS
38
9-89

JUN 05 2017

P/O: 36405

use P/O: meter machine 6 per day.

read + inspect attached c/c to W/O: 6XSP17-5-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER :							

Work Order ID 160829

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160829

Page 2

Item ID: PB67-43001-247

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Inner Tube

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Required Date: 5/17/2017 Req'd Qty: 7.00

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Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.14							
Quality Control									
140	Identify as per dwg & Stock Location: WAB	0.00							
140									
Packaging	Memo	0.07							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.70							
Quality Control									

6 **JUN 05 2017** **DAS 24 9-89****17/6/7** **28****W** **JUN 05 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Thursday, May 04, 2017 2:48:38 PM

Page 1

Work Order ID: 160829

160829

Parent Item: PB67-43001-247

PR67-43001-247

Parent Item Name: Inner Tube

Start Date: 5/10/2017

Required Date: 5/17/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.250W.125		Purchased	No			100	f	26.8460	4.4042	32.452			DAS
M6061T6T1 250W 125									** 27.82			MAY 23 2017	13 9-89
ALUM. RD TUBING 1.250 x.125W													

Location

Loc Qty

Loc Code

MAT

26.846

m132577

12.002

m135249

14.844

m137541

DQA: _____ Date: _____



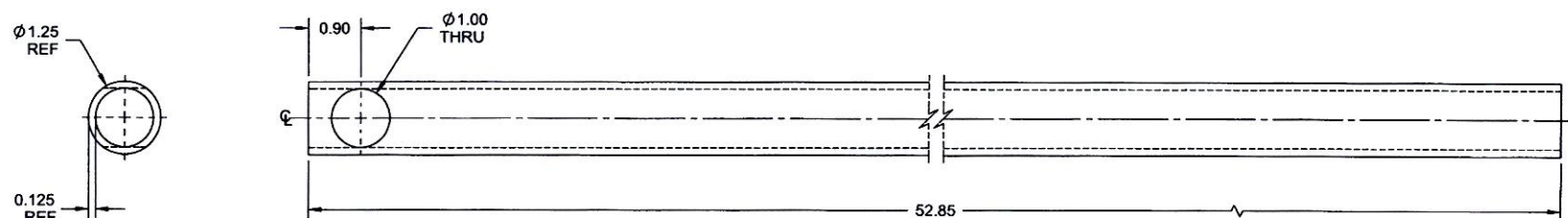
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐	
Misidentified ☐	Past Due ☐																																																														

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160829 1705-01



B67-43001-247 INNER TUBE

RELEASED
2009-09-24
MB

- NOTES:**
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T1.250W.125
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.26 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 23 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.	AS	B67-43001-247	SHEET 1 OF 1	
APPROVED	AS	TITLE	SCALE	
DE APPR.	N/A	INNER TUBE	NTS	
DATE	09.02.27		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36405**

Purchase Order Date 5/23/2017

PO Print Date 5/23/2017

Page Number 2 of 5

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613 678 3957

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

3	160817	PB67-43001-257 INNER TUBE	6/7/2017	7.00	\$0.00	\$0.00
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Yes

6/7/2017

MACHINE AS PER DWG PB67-43001-257

MATERIAL 6061-T6 ROUND TUBING 1.250" X .125" WALL M137541,M13524,M132577 TUBING ALREADY CUT TO LENGHT

Line Total: \$0.00

4	160829	PB67-43001-247 INNER TUBE	6/7/2017	6.00	\$0.00	\$0.00
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Yes

6/7/2017

MACHINE AS PER DWG PB67-43001-247

MATERIAL 6061-T6 ROUND TUBING 1.250" X .125" WALL M137541

Line Total: \$0.00

5	160833	PB67-43001-255 INNER TUBE	6/7/2017	7.00	\$0.00	\$0.00
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Yes

6/7/2017

MACHINE AS PER DWG PB67-43001-255

MATERIAL 6061-T6 ROUND TUBING 1.250" X .125" WALL M137541

Note:

5/23/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21703
Date: May 29, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 36405	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: May 29, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D5159-3 Seat Rib, as per drawing D5159-3 Rev. A	Each	6		6
PB67-43001-127 Handle Arm, as per drawing PB67-43001-127	Each	5	5	0
PB67-43001-257 Inner Tube, as per drawing PB67-43001-257	Each	7	7	
PB67-43001-247 Inner Tube, as per drawing PB67-43001-247	Each	6	6	
PB67-43001-255 Inner Tube, as per drawing PB67-43001-255	Each	7	7	
PB67-43001-259 Inner Tube, as per drawing PB67-43001-259	Each	7	7	
PB67-43001-285 Upper Tube, as per drawing PB67-43001-285	Each	5		5
PB67-43001-197 Outer Tube, as per drawing PB67-43001-197	Each	7		7
PB67-43001-229 Outer Tube, as per drawing PB67-43001-229	Each	7		7
PB67-43001-235 Outer Tube, as per drawing PB67-43001-235	Each	7		7
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by <u>Sp 17-5-30</u>		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

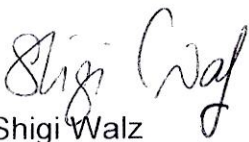
same

Quantity	Part Number	Part Name	Material & Batch #	P.O. Number
7	PB67-43001-257	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541, M13524, M132577	36405
6	PB67-43001-247	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541	36405
7	PB67-43001-255	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541	36405
7	PB67-43001-259	Inner Tube	6061-T6 round tubing 1.250" x .125" wall M137541	36405

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, May 29, 2017

DAS
38
5-89